

**Work Order ID 68359**

Tuesday, April 12, 2011 10:11:29 AM



Page 1

Item ID: D3294-5

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 4/12/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:



Date: 140412 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr								
100									

100

0.00



Waterjet

Memo

0.00

B11-4-21

FLOW CNC Waterjet

2024 .080

1-Cut as per Dwg D3294

Dwg Rev:

Prog Rev: C

\*\*\*\*grain direction as per dwg D3294 \*\*\*\*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

B11-4-21

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Dw04125

(XK)

130



Brake NC

Brake NC

Memo

0.00

1- Deburr if necessary

2- Bend as per Dwg D3294

0.00

SB 1104125

(11)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sw0412c

(TC)

W/O:		WORK ORDER CHANGES					
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Customer:

**Reference:**

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours**

Tool ID

Tool #

**Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

150



Chemical Conversion Coat per QSI005 4.1

0.00

11 BR 11-4-26.

HandFinish

Memo

0.00

Hand Finishing

160



QC3- Inspect Part Finish

0.00

11 d 11-4-26

QC

Memo

0.00

Quality Control

170



Identify as per dwg &amp; Stock Location: 6A

0.00

25/04/26 11x

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/4/27  
MK

11-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

## Picklist Print

*Tuesday, April 12, 2011 10:11:35 AM*

Page 1

**Work Order ID:** 68359



**Parent Item:** D3294-5



**Parent Item Name:** Doubler

**Start Date:** 4/12/2011

**Required Date:** 4/15/2011

#### Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	51.0000	0.065	0.821053			10-14-20

2024-T3 .080 sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	51	
104921	1	104921
105411	6	
109424	4	
110347	2	
110908	3	
112331	3	
113796	7	
114025	17.2	
116604	7.8	

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DART AEROSPACE LTD	Work Order:	68359
Description: Doubler	Part Number:	D3294-5
Inspection Dwg: D3294	Rev: C	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-4-21	Date:	11/6/21	Date:	N/A

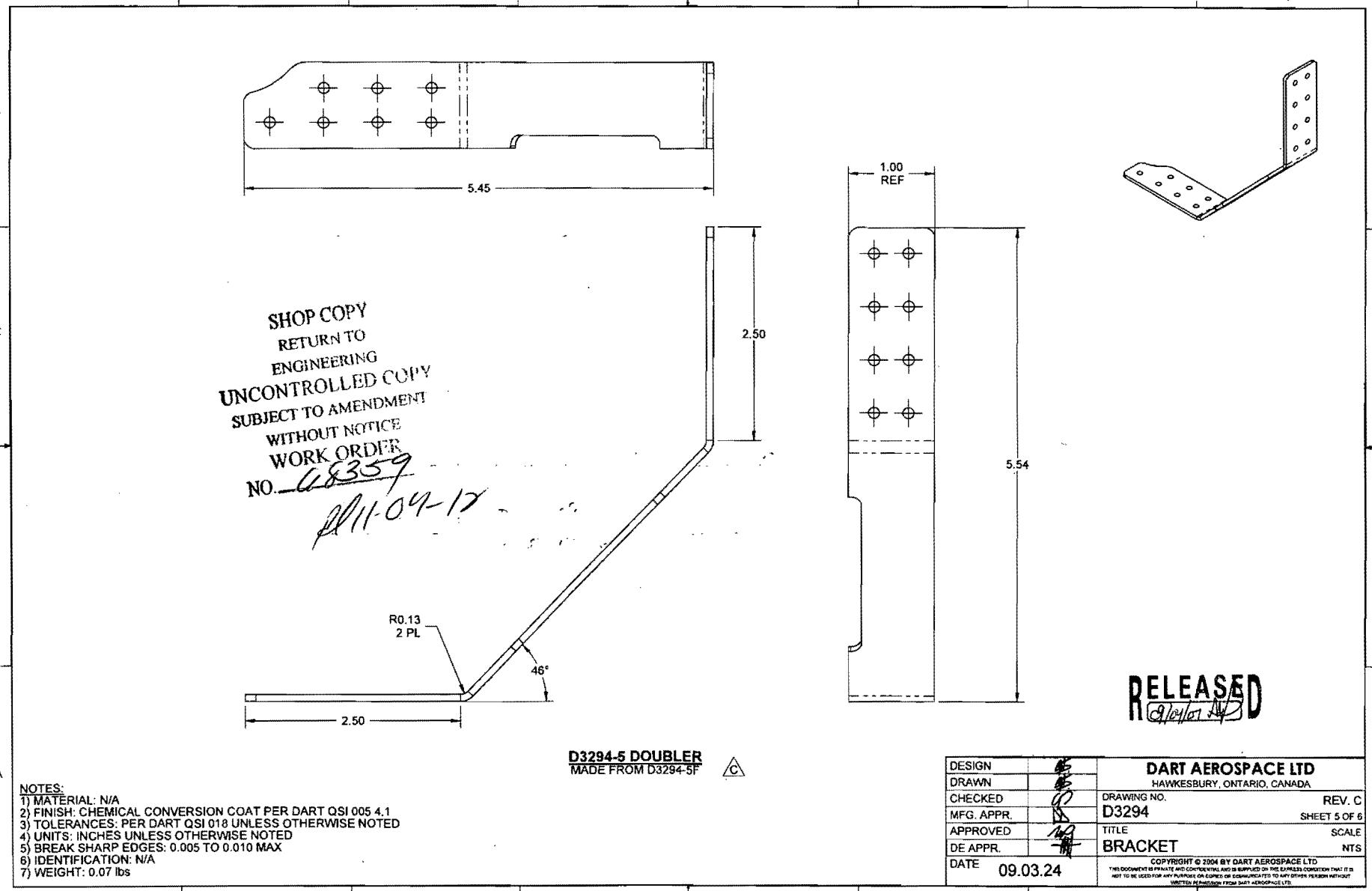
Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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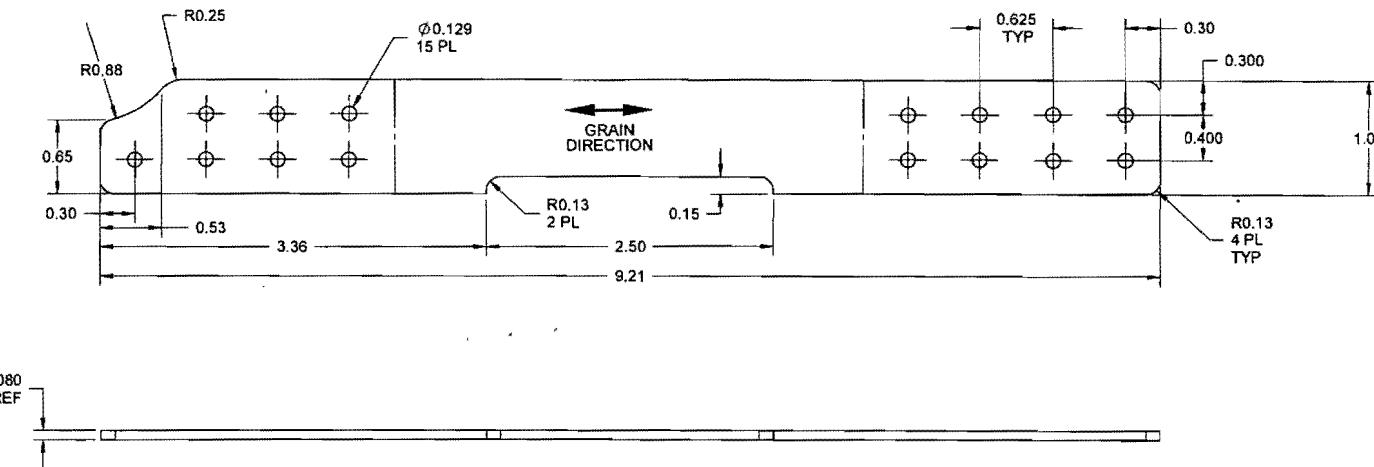
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**D3294-5F DOUBLER FLAT PATTERN**

RELEASED  
09/04/07 MTC

**NOTES:**  
1) MATERIÁL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4  
OR AMS 4037 (REF DART SPEC M2024T3S.080)  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.07 lbs

Per 10 48355

DESIGN	<u>55</u>	DART AEROSPACE LTD	
DRAWN	<u>55</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>55</u>	DRAWING NO.	REV. C
MFG. APPR.	<u>NA</u>	D3294	SHEET OF 6
APPROVED	<u>NA</u>	TITLE	SCALE
DE APPR.	<u>NA</u>	BRACKET	NTS
DATE	09.03.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS EXCLUDED FROM THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

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